



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2654-5

Job Sheet 186223



Part No: D2654-5

Job Qty: 5 ea

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEET 2 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Skid tubes-2		Mab
100	Skid tubes	5 pcs	12/7/18	12/7/18	0.00	2.73	Skid tubes-3		Mab
110	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC5		DR 18/11/14
120	HandFinish	5 pcs	12/7/18	12/7/18	0.00	1.19	HandFinish1		Mab
130	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC7-1		Mab
140	Packaging	5 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-1		Mab
150	QC21-SA	5 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DAS NOV 16 2018

Part Op 100 - 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
Descriptions: 140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-7-140	Extrusion I-Beam Thick	5 Ea (1 ea)	90-Start up Operation	5046288

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-7-140	5	150	0

Part Specifications

Specifications could not be found.

Plex 11/13/18 9:05 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

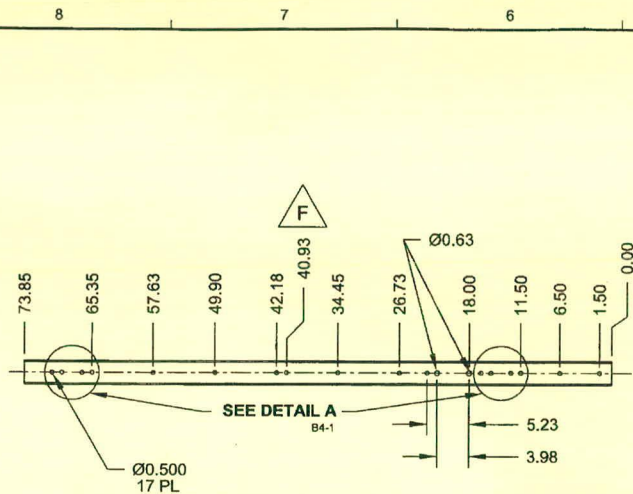
WORK ORDER NON-CONFORMANCE / UPDATE



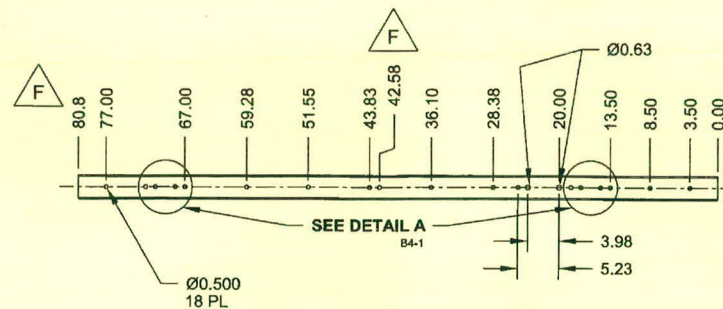
QA Closed: _____ Date: _____

Work Order update only ☐

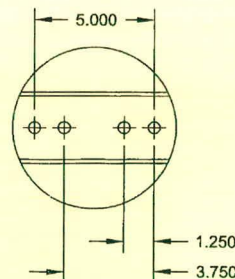
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		2) Approval			
Description Work Order Deviation 12/11 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-8200 Email: sales@dartaerospace.com www.dartaerospace.com DART AEROSPACE Contact: 1-813-632-8200 Part: D2654-5 Job No: 186223 Serial No/Batch: S127362 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/13/18							



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

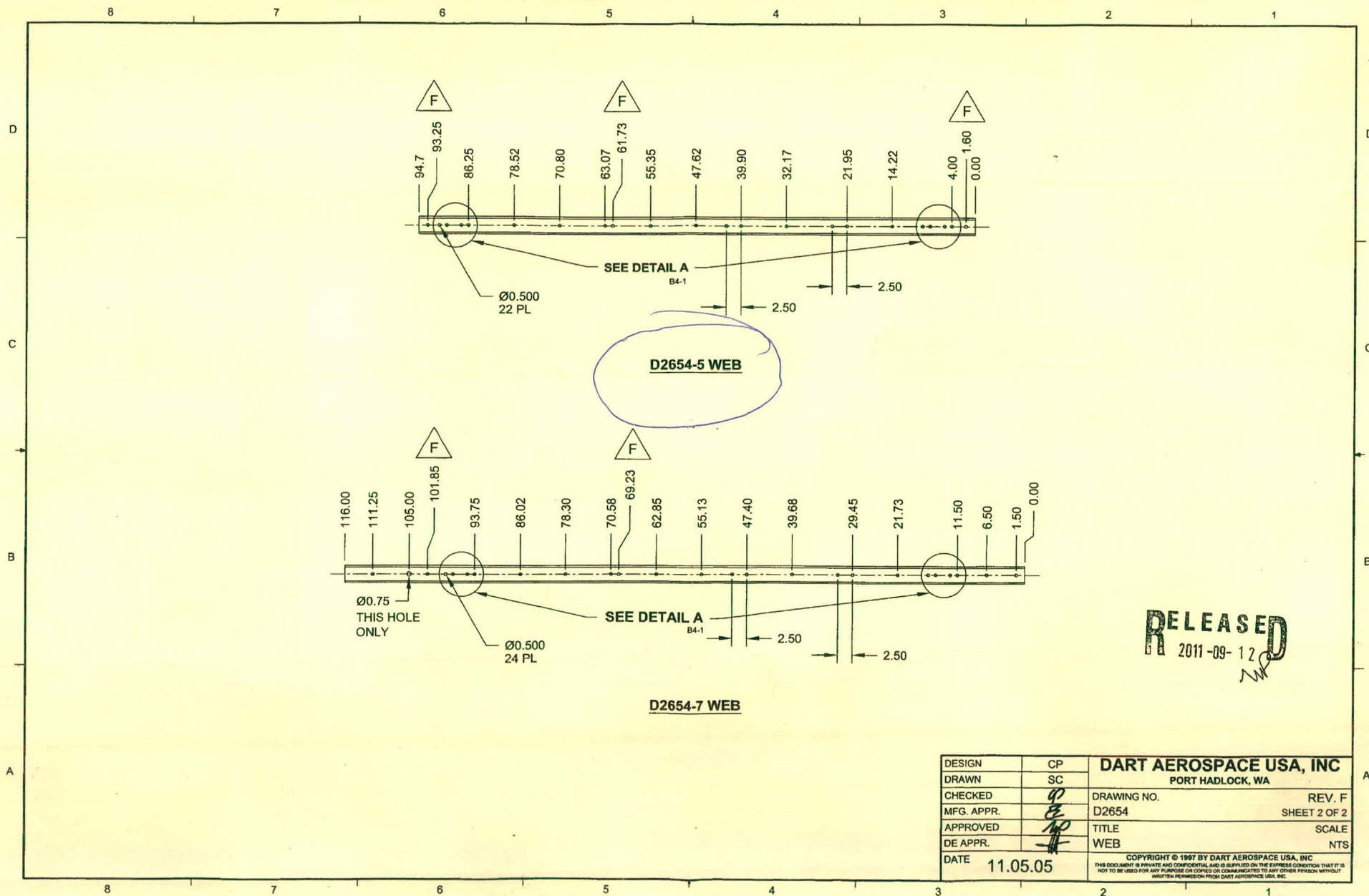
NO. 186223 M.C.
18-11-13

RELEASED
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D2654	SHEET 1 OF 2
APPROVED	90	TITLE	SCALE
DE APPR.	90	WEB	NTS
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DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>JP</i>	D2654	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
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